

Date: Thursday, 11/12/2008 10:45:01 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (BASKET LID, LH)
Job Number : 44020	
Estimate Number : 13665	
P.O. Number :	Part Number : D3838041
This Issue : 11/12/2008 S.O. No. :	Drawing Number : D3838 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 22/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 08-12-11</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D37591	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

batch: B44059

SP 09/01/06 4x

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 1.0833 f(s)/Unit Total: 4.3331 f(s)



304 SQ Tube .75x.75x.065W

batch: M110011

SAD 08-12-23 (4)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3838-1 and D3838-3 rib as per dwg D3838

SAD 08-12-23

2- drill hole in D3838-1 as per dwg D3836 using DT9437 jig

~~SAD 08-12-23~~ SP 09.01.05 (4)

3- c'sink hole as per dwg

4- remove identification markings

SAD 08-12-29

5- deburr

SAD 08-12-28



4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08-12-30 (4)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- weld D3759-1 bushing as per dwg D3838

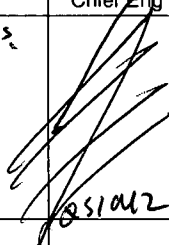
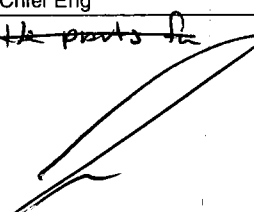
2- grind bushing weld flush as per dwg dwg D3838

SP 09.01.05 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-12-30	3.0	<del>Qty 4 parts cut as -2's</del> <del>thing is clear.</del> <del>the lack of attention to</del> <del>thing detail.</del>	 05/01/12	<del>Identify the parts for</del> N/A				

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:45:01 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, LH)

Job Number: 44020

Part Number: D3838041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- deburr hole if necessary

4- weld D3838-1 to D3838-3 as per dwg D3838 using DT9447 welding jig

\*\*\*\*after welding ensure measurements are good\*\*\*\*

A/R ER316 S.S. Rod Batch: M 106762

5- grind weld flush where indicated on dwg D3838

SP 09.01.06  
JY 09/01/06  
~~SP 09.01~~

6.0

QC9

VISUAL WELDING INSPECTION



CP 09-01-06



(4)

Comment: VISUAL WELDING INSPECTION

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BASKET CELL

JY 09/01/06 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 09/01/08  
ME 09-01-08

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

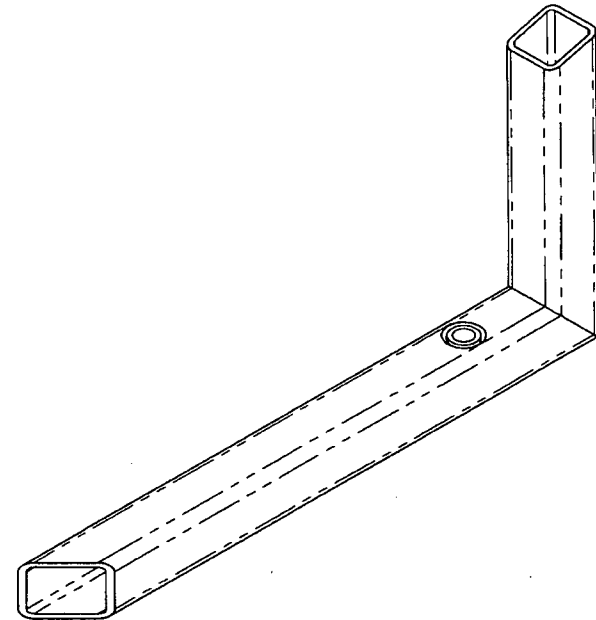
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

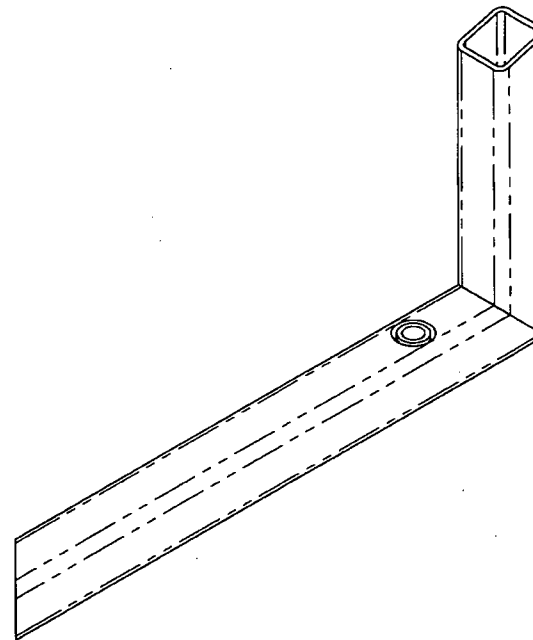
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

**NOTES:**

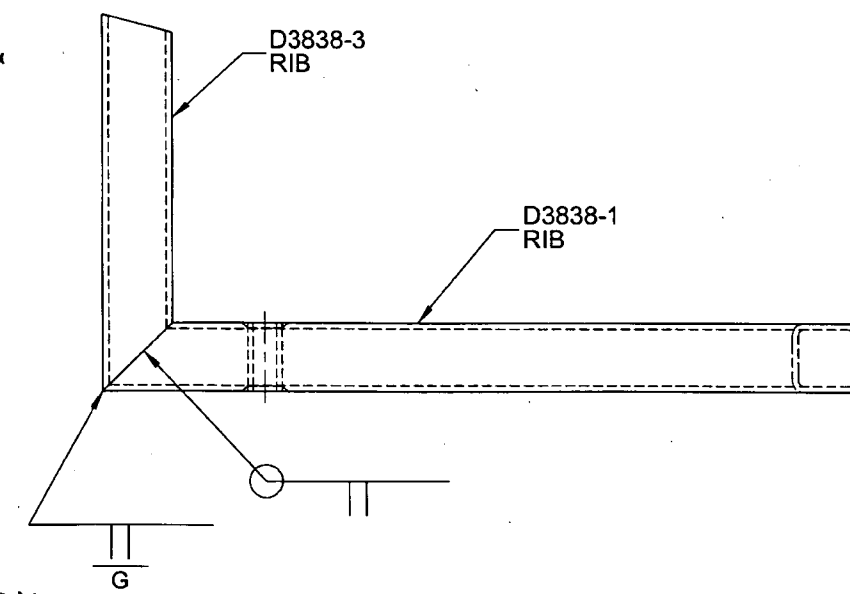
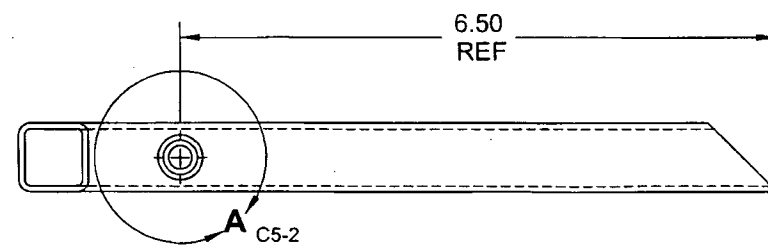
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

**RELEASED**  
08/11/08

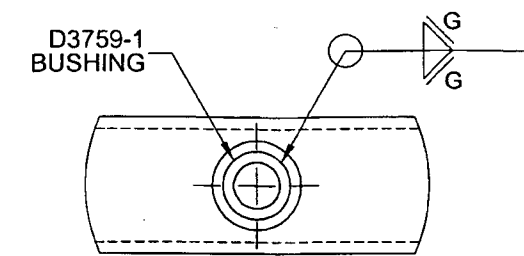
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WORK ORDER  
NO. 44020

DESIGN	NEW ISSUE	MB	08.10.08
REV.		BY	DATE
DESCRIPTION			
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO.	REV. A
CHECKED		D3838	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		RIB ASSY (BASKET LID)	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.10.08		

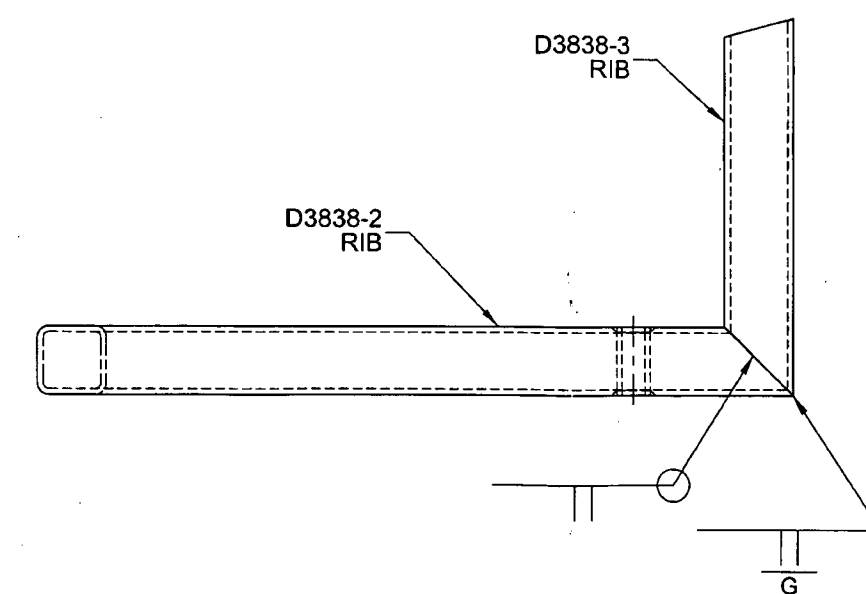
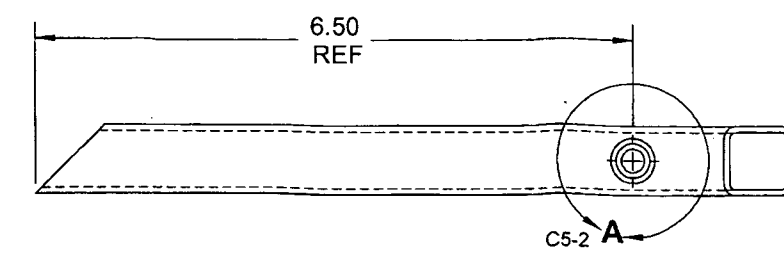




**D3838-041 RIB ASSY (BASKET LID, LH)**



**DETAIL A**  
D2-2  
D7-2 SCALE 2X



**D3838-042 RIB ASSY (BASKET LID, LH)**

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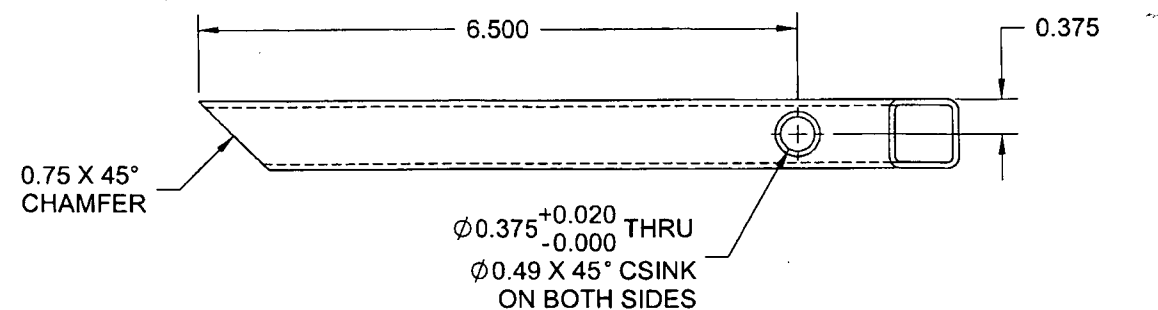
4

3

2

1

D

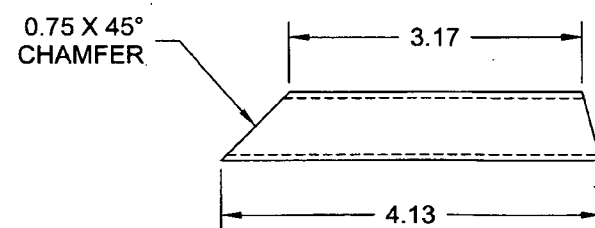
0.75 X 45°  
CHAMFER

8.25

**D3838-1 RIB**

C

B

**D3838-3 RIB**

A

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

8

7

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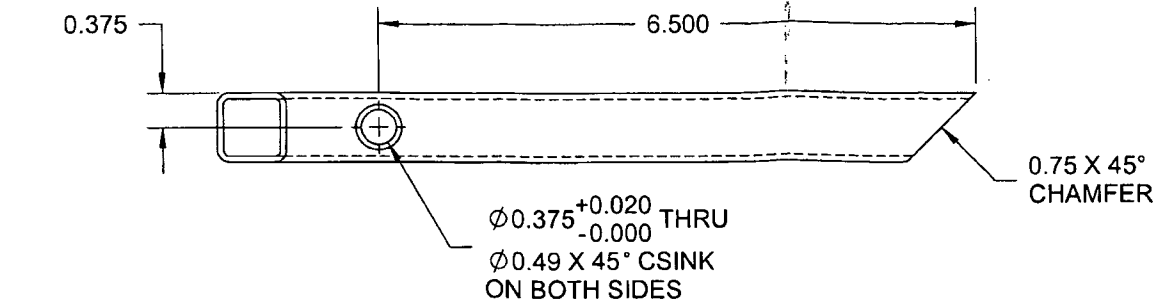
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2

1

0.75 X 45°  
CHAMFER

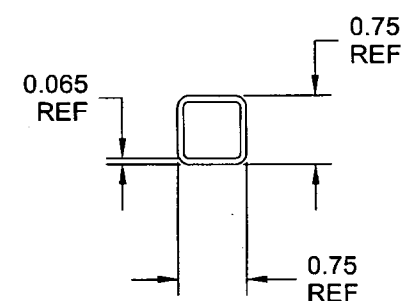
8.25

**D3838-2 RIB**

D





C

B

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MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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